

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006914**Date Inspected:** 05-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

**Outside yard near Bay #11**

East Tower Lift#1:- Caltrans QA Inspector observed six ZPMC welders in process FCAW process on fit lugs of interior diaphragms. The fit lugs located at the elevation 53m to 80.75m diaphragm sections of skin plate A. Total 10 fit lugs have to weld to complete on this skin plate A. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

East Tower Lift #1:- Caltrans QA Inspector observed ZPMC and ABF QC performed final VT inspection on the exterior skin plate C. During VT inspection a numinous surfaces have been rejected with arc strikes, slag, excess weld metal and base metal damage. All of rejected surface have been marked with white marker and schedule to grinding and repair welding.

**Bay #11 South and North Tower Shop**

East Tower Lift#2:- Caltrans QA Inspector observed five welders performed FCAW process on PJP welds for corner diagonal stiffener that connected skin plate C to D and B to C. The PJP welding located along at elevation 53m to 80.76m diaphragm. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans observation, no discrepancies were noted.

West Tower Lift#2:- Caltrans QA Inspector observed six ZPMC welders in process FCAW process on interior

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diaphragms of skin plate E. The interior diaphragms located at the elevation 53m to 80.75m. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West tower lift#1:- Caltrans QA Inspector observed five ZPMC welders in process FCAW process on interior diaphragms of skin plate E. The interior diaphragms located at the elevation 9m to 47.6m. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

East Tower Lift #3:- Caltrans QA Inspector observed five ZPMC welders in process fit up and SMAW tack welding on skin plate E to of east tower lift 3. A numerous temporary tack welds have been welded attach to the skin plate E have been secured and connected to skin plate A. Base on Caltrans QAI observation, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As noted within the report above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau, Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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